

5/12

w/o SPLIT

DART AEROSPACE LTD	Work Order:	22479C
Description: Battery Lock Casing	Part Number:	D3393-1
Dwg: D3393 Rev. A page 2	Qty:	61 100 88
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PH	05.02.21	100
2	MV	Cut blank: 1.500" x 1.500" x 3.125" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.500x01.500) Identify for D3393-1	SD	05.02.25	88
		Batch: M16954 M10416			
3	MV	Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1	SD	05.02.23	88
4	QC2	Inspect parts as they come off the CNC machine	SD	05.02.23	88
5	QC8	Second check	FE	05.03.08	88
6	MV	Deburr	SD	05.02.23	88
7	QC5	Inspect work to Step 6	FE	05.03.07	88
8	FP	Chemical Conversion Coat as per QSI 005 4.1	SG	05.03.09	88
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	M	05.03.10	88
10	QC3	Inspect Powder Coat	SB	05/03/14	88
11	ST	Identify and Stock	SB	05/03/14	61
12	AC	Cost / part 2.63	SG	05.03.16	61
13	DC	Close W/O 8.31 Inspect Level 21	KJ	05.03.18	61

Rev	Date	Change	Revised By	Approved
A	05.02.18	New issue	KJ/JLM	

RELEASED
05.02.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

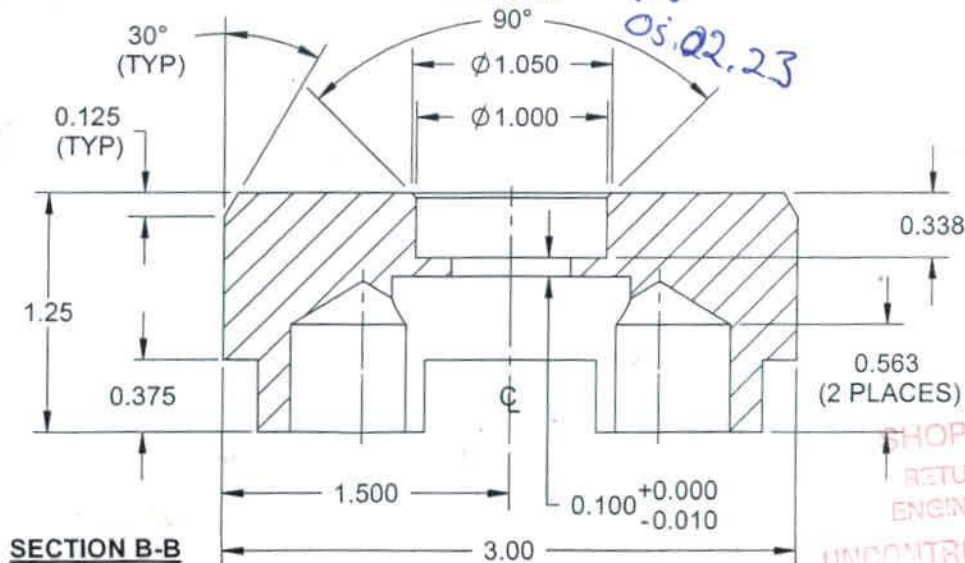
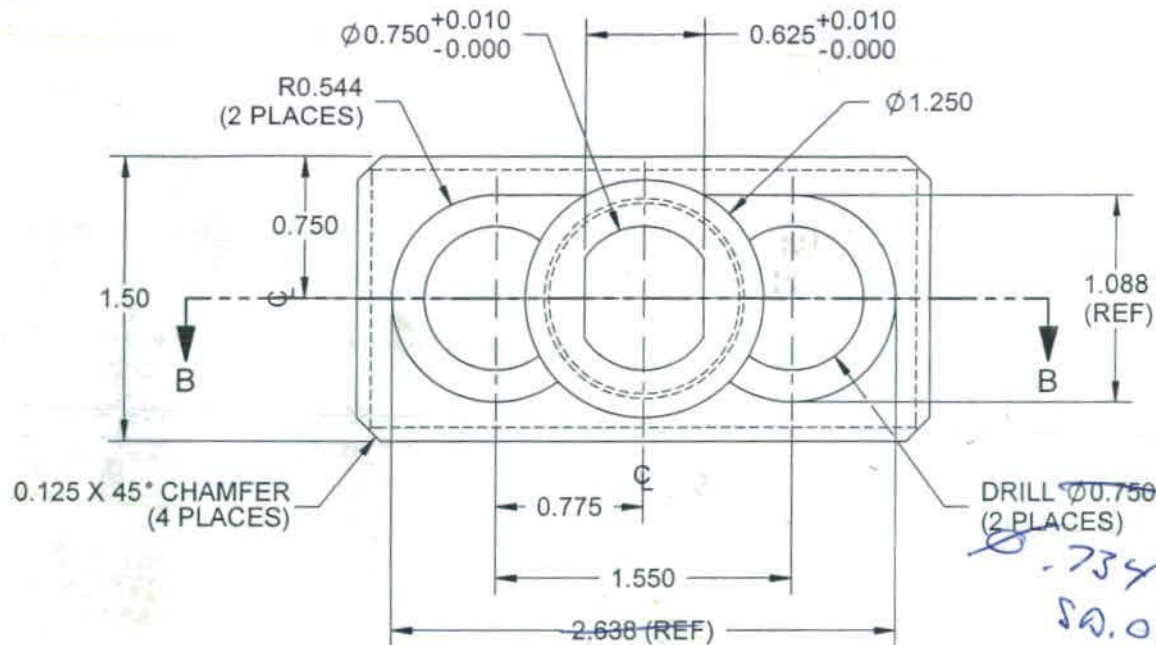
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3393	REV. A
DATE 05.02.09		TITLE BATTERY LOCK	SHEET 2 OF 3 SCALE 1:1



SECTION B-B

D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 22479

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 21, 2005
02:21 pm

Work Order No : 0022479
Project Name : D3393-1
Project For : WK512
Work Order Type : Main
Main WO Number :
House Part Number : D3393-1
Description : Battery Lock Casing
Manufactured : Yes
Amount Req'd : ~~100~~ 88
Amount Done : 0
Start Date : 02-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 22479 B
Description:		Part Number: 03393-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .730	+0.010 -0.000	.734	✓			
.625	+0.010 -0.000	.631	✓			
Ø 1.250		1.248	✓			
1.088		1.089	✓			
Ø .734		.735	✓			
2.658		2.657	✓			
.125x45°		.128x45°	✓			
dx 1.550		1.550	✓			
.775						Good! Cannot measure
1.50		1.490	✓			
.750		.740	✓			
90°		90°	✓			
Ø 1.050		1.050	✓			
Ø 1.000		.991	✓			
.338		.342	✓			
.563		.571	✓			
.100	+0.000 -0.010	.101	✓			
3.00		3.002	✓			
1.500		1.500	✓			
.375		.382	✓			
1.25		1.255	✓			
.125x30°		.135x30°	✓			

Measured by: SD	Audited by: JML	Prototype Approval:
Date: 03/03/02	Date: 05/03/02	Date:
Rev: A	Date:	Change: New Issue
Revised by: KJ/JLM	Approved:	

